

Date: Tuesday, 4/17/2007 3:57:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 31937				
Estimate Number	: 12712				
P.O. Number	: N/A		Part Number	: D35371	
This Issue	: 4/17/2007	S.O. No. : N/A	Drawing Number	: D3537 UNDER REVIEW PH	
Prsht Rev.	: NC		Project Number	: N/A 07.04.26	
First Issue	: N/A		Drawing Revision	: A/B	
Previous Run	: 31725		Material	: N/A	
Written By	:		Due Date	: 5/20/2007 Qty: 40 Um: Each	
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 07-02-14 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s) M304S16GA .063" 304 SS SHEET Batch: M103961	<i>SAP 07/05/13</i>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	<i>SAP 07/05/13</i>
		2-Deburr if necessary	<i>MF 07-05-17</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAP 07/05/13</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>MF 07-05-17</i>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	<i>MF 07-05-17</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

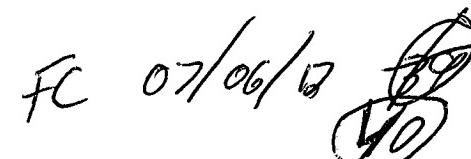
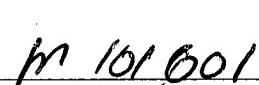
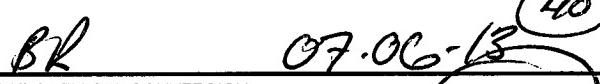
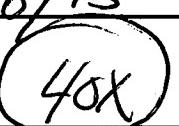
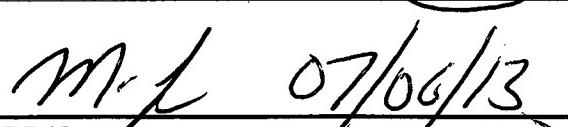
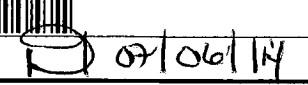
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 31937		Part Number: D35371
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		 
Qty	Description	Batch
A/R	2059B Hardcoat	M102956
1-Weld as per Dwg D3537 using Jig DT 8210		
2-Remove any weld that penetrated through Wearpadif necessary		
7.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING		 
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: F-18		 
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 
Job Completion		 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

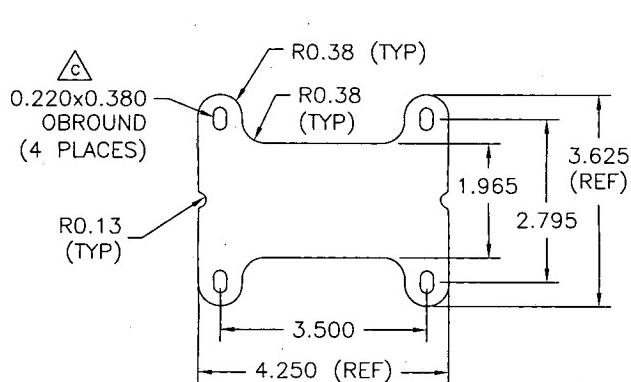
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

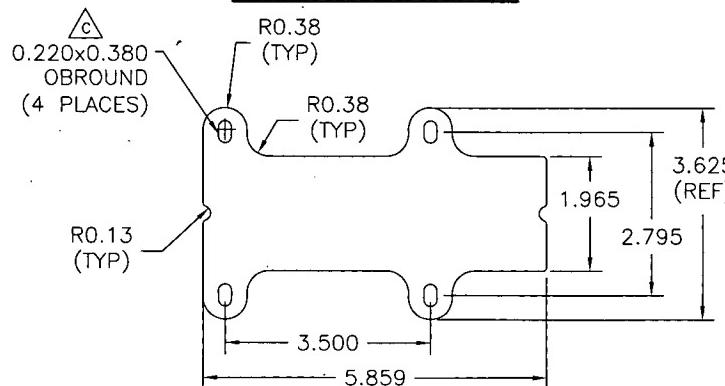
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

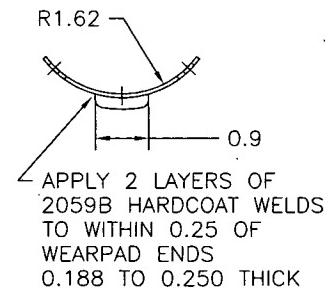
### D3537-1F FLAT PATTERN



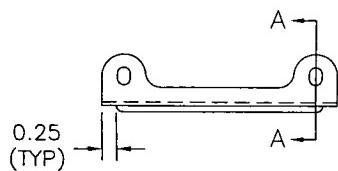
### D3537-3F FLAT PATTERN



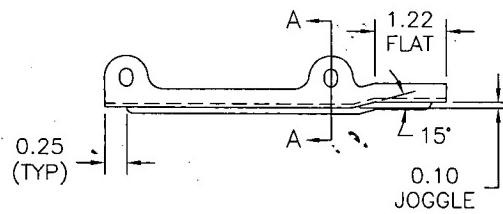
### SECTION A-A



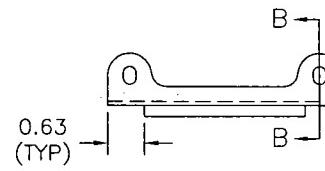
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



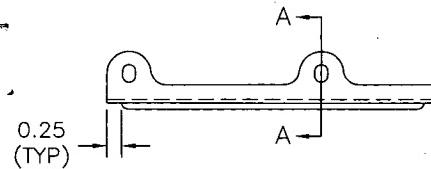
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CB	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
		REV. C SHEET 1 OF 1
DATE	TITLE	SCALE
07.04.13	WEARPAD	1:2

31932

31725

DART AEROSPACE LTD	Work Order:	31725
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: A B	Page 1 of 1

34 07.04.27

## **FIRST ARTICLE INSPECTION CHECKLIST**

X

First Article

## Prototype

Measured by:	SAD
Date:	03/05/13

Audited by:	
Date:	07.05.13

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM <i>[Signature]</i>	EZ